

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2590	REV. C SHEET 1 OF 2
DATE 98.08.28		TITLE 204 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.28	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED
98/09/11 DS

QTY	Part Number	Description
X	D2590-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2597	204 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
17	D2579	CROSS BOLT SPACER
10	D2594-1	PLUG
10	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-7	WEARSHOE
38	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
40	AN3-4A	BOLT
40	AN960JD10L	WASHER

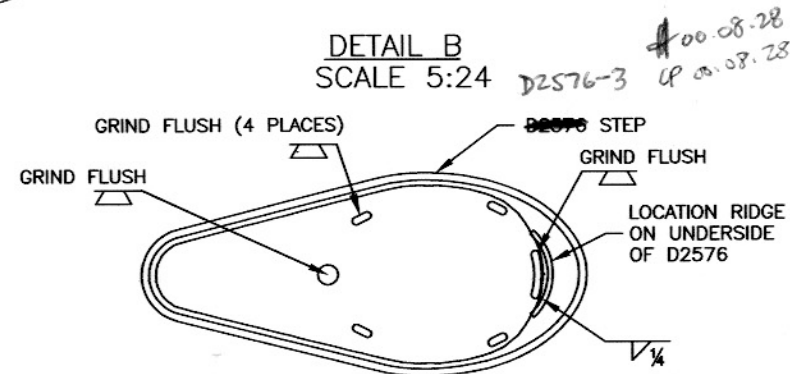
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EFFECTIVE	DEOS
98/12/14	

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 169.5 INCHES *
- 3) INSERT D2597 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-204 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (38 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2597 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES).

Diagram illustrating the cross-section of a pipe with four vertical stiffeners. The stiffeners are spaced 3.500 units apart. The distance from the centerline to the outer edge of the stiffeners is 1.750 units.



Ø0.208

DRILL PRIOR TO D2575 CAP
INSTALLATION (2 PLACES)

AN3-4A BOLT (1)

AN960JD10L WASHER (1)
(2 PLACES)

D2575 CAP

0.40

SEAL WITH
SIKAFLEX-241

D2579 SPACER

D2597 WEB (REF)

ALS7-1032-130 (REF)
(TYP 38 PLACES)

AFTER
PERFO

1. CHA
2. INS
3. WEI
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (17 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

37.50
DISTANCE TO AFT END
OF D2596 WEB

3
7

1.750

1.750

Ø0.508 (TYP.)
(34 PLACES)

REFER TO DETAIL A

REFER TO DETAIL A

8.750

17.375

26.000

35.000

36.000 (REF)
4 EQUAL SPACES
9.00 PITCH

71.000

38.0

169.5
(D2500-1)

Technical drawing of a road cross-section showing a 4% upward grade. The drawing includes dimensions for the road width (13.4m), distance between hole and tangent point (1.0m), distance between hole and tangent point (6.5m), and a 37.5m section. A hole is shown with a diameter of 0.640m. The road surface is 11.5m high. A 1.4m dimension is also shown on the left side.

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

1.5

0.5

1.5

1.5

1.5

1.5

D

P

P

P

P

REFER TO DETAIL C

D2577-3

D2577-7


D2577-1

AN3-4A BOLT (1)
AN960J10L WASHER (1)
(38 PLACES)

8

RELEASED
48/09/17 DS

ORIGINAL COPY ISSUED

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D2590	REV. C SHEET 2 OF 2
DATE 98.08.28		TITLE 204 SKIDTUBE ASSEMBLY	SCALE 1:24



DESIGN <i>DM</i>	DRAWN BY <i>JE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>JE</i>	DRAWING NO. DEO 9124	REV. A SHEET 1 OF 1
DATE 98.12.12		TITLE CHANGE TO AFT CAP	SCALE NTS
A	98.12.12	NEW ISSUE	

DART ENGINEERING ORDER

AMENDS DRAWING D2580 REV. C
AMENDS DRAWING D2590 REV. C

REPLACE: (1) D2575 CAP (SPUN)
(2) AN3-4A BOLT

WITH: (1) D2855 CAP (CASTING)
(2) AN3-5A BOLT

Superseded

RELEASED
98.12.14 DS